

Date: Friday, 9/7/2007 10:14:55 AM
 * User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE BRACKET, GAS SPRING
Job Number : 34465	
Estimate Number : 10179	
P.O. Number :	Part Number : D2144
This Issue : 9/7/2007 S.O. No. :	Drawing Number : D2144 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 33883	Material :
Written By :	Due Date : 9/14/2007 Qty: 20 Um: Each
Checked & Approved By : <u>9/07.09.07</u>	
Comment : Est: D 04.05.06 Reformat KJ/RF	
Est Rev:E Now on Waterjet 06-10-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0945 sf(s)/Unit Total : 1.8900 sf(s)
 304/316 .063 Sheet 16GA
 Batch: M105130

SAD 03/09/08 24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2144
 Dwg Rev: D
 Prog Rev: D

2-Deburr if necessary

SAD 03/09/08 24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/09/08 24

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Sn 04/09/10 counter 24

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary

Jhm 07/09/11 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/7/2007 10:14:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

#01 30 m
23/01/2008
S.00001 09.20
#1 387.5 F
#2 386.9 F

Job Number: 34465

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2144

Rev: ①

28 8

#01 30 m
S.00002 09.50
#1 388.9 F
#2 388.1 F

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/16

#01 30 m
23/01/2008
09.50
S.00002

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FAB RESOURCE 1

1- Weld corner as per Dwg D2144 & QSI 004

2- Grind flush

FL FL

FL 08 01 16

24

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08-01-17 24

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/01/17 24

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

TICKET #01 M 106379

BK 08-01-23

24

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

16 8/07/04 24

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST198A

16 8/1/24 24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/7/2007 10:14:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET, GAS SPRING

Job Number: 34465

Part Number: D2144

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08.01.24
JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2008/1/24

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	34465
Description: Hinge Bracket		Part Number:	D2144
Inspection Dwg: D2144 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.381	+/-0.010	3.384	✓		Height gage	
3.022	+/-0.010	3.022	✓		Vern	
2.468	+/-0.010	2.470	✓		Height gage	
1.913	+/-0.010	1.911	✓		Vern	
1.555	+/-0.010	1.551	✓		Height gage	
4.126	+/-0.010	4.130	✓		Vern	
3.465	+/-0.010	3.462	✓		Vern	
0.340	+/-0.010	0.338	✓		Vern	
0.625	+/-0.010	0.630	✓		Height gage	
1.000	+/-0.010	0.996	✓		Vern	
1.083	+/-0.010	1.083	✓		Vern	
1.660	+/-0.010	1.658	✓		Vern	
2.312	+/-0.010	2.311	✓		Vern	
2.844	+/-0.010	2.847	✓		Vern	
3.294	+/-0.010	3.296	✓		Vern	
Ø0.257	+0.006/-0.001	Ø0.261	✓		Vern	
Ø0.171	+0.005/-0.001	Ø0.173	✓		Vern	
Ø0.320	+0.006/-0.001	Ø0.322	✓		Vern	
0.354	+/-0.010	0.353	✓		Vern	
0.063	+/-0.010	0.059	✓		Vern	

Measured by:	SAD	Audited by:	Dr	Prototype Approval:	N/A
Date:	07/09/08	Date:	07/09/10	Date:	N/A

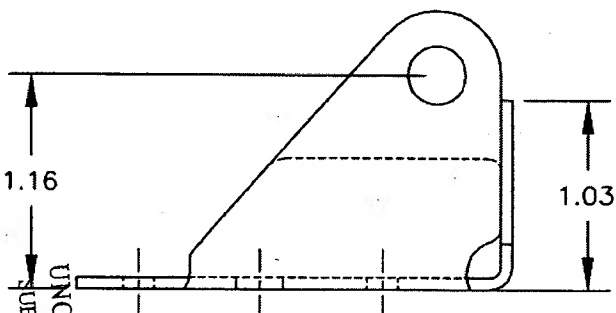
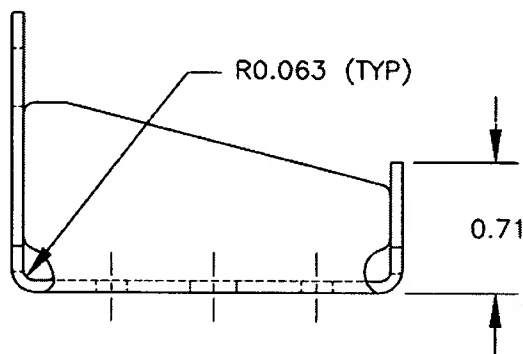
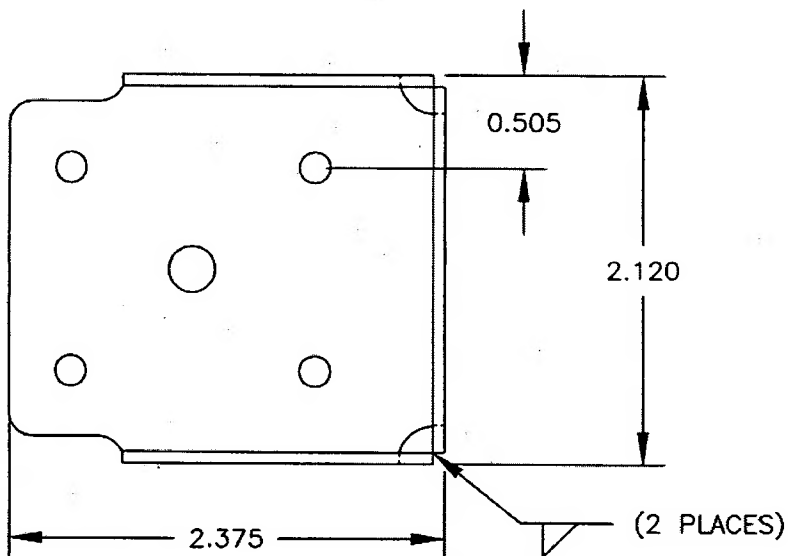
Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	<i>[Signature]</i>

DART



RELEASED
98.10.15 KE

DESIGN	BW	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	MA	APPROVED	KE	DRAWING NO. D2144
DATE	98.10.08	TITLE	HINGE BRACKET	REV. D SHEET 1 OF 2
A	95.03.17	NEW ISSUE		SCALE 1:1
C	96.06.05	FLAT PATTERN LAYOUT ADDED		
D	98.10.08	UPDATED DIMS AFTER BEND (TSR A917)		



FINISH: POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

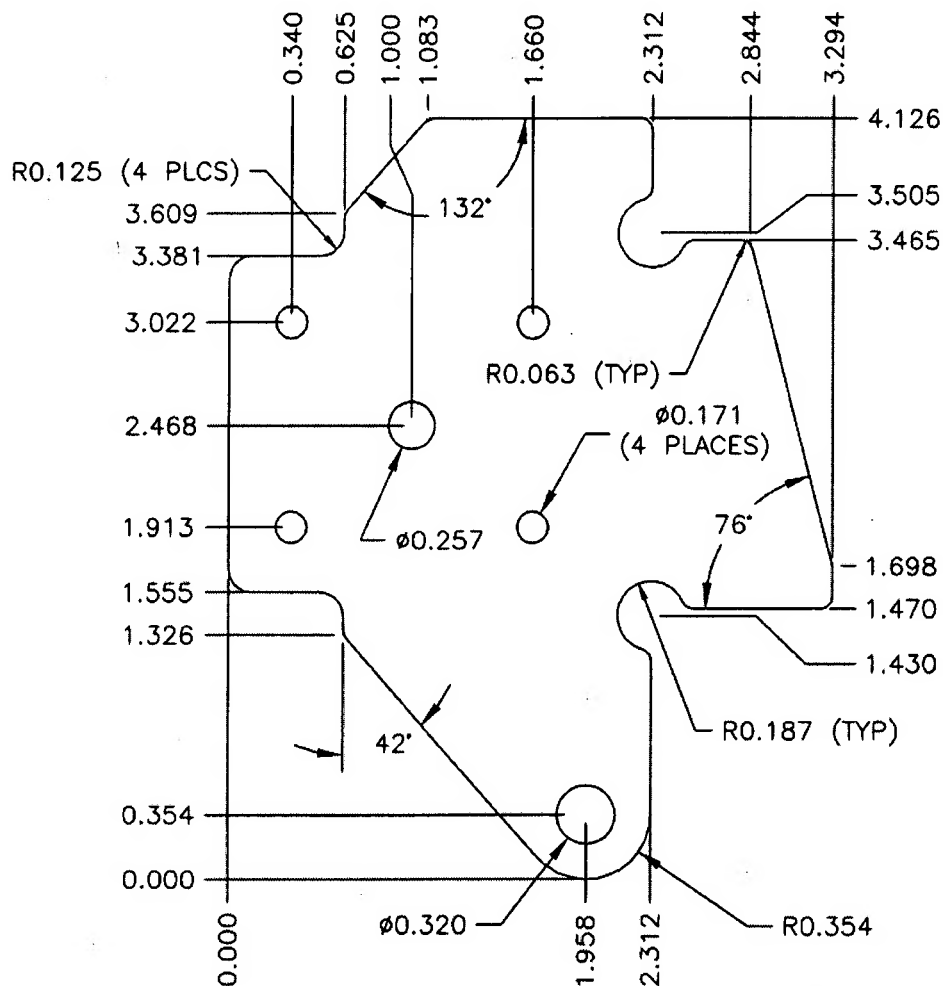
SHOP COPY
RETURN TO
ENGINEERING

WORK ORDER
NO. 34465



DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2144	REV. D SHEET 2 OF 2
DATE 98.10.08	TITLE HINGE BRACKET		SCALE 1:1

RELEASED
98.10.15 KE



D2144 FLAT PATTERN

MATERIAL: AISI 304/316-2B SS, 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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ENGINEERING
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WORK ORDER
NO. 34465